

B 106338

Work Order ID 106338

106338

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August-29-13 8:23:55 AM

Item ID: D4542-5 **D 4 5 4 2 - 5** Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: RETAINER, INNER
 Start Date: 8/29/13 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4542	D								

100
100 **REV. D** 0.00 40 0 Jm13-09-10
 Waterjet Memo
 FLOW CNC Waterjet 1- Cut as per dwg 0.00
 Prog rev: D
 Dwg rev: D
 2- Deburr

110
110 QC2- Inspect parts off machine FAI/FAIB 0.00 40 0 Jm13-09-10
 QC Memo
 Quality Control

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Item ID: D4542-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: RETAINER, INNER

Start Date: 8/29/13 Start Qty: 40.00

40

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

120

QC

Memo

Quality Control

0.00

0.00

SAS
27
13 9 1040
count

125 Chemical Conversion Coat per QSI005 4.1 0.00

125

HandFinish

Memo

Hand Finishing

0.00

0.00

40 7/6/13-9.4

127 QC7-Inspect Chemical Conversion Coat 0.00

127

QC

Memo

Quality Control

0.00

0.00

SAS
27
13 9 1246
count

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Item ID: D4542-5 Accept *N900040100* Setup Start *NS1*
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 Item Name: RETAINER, INNER
 Start Date: 8/29/13 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00							DAS 26 89
130						40x			
Packaging	Memo	0.00							B-9-16
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PL/B09-16

Picklist Print

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Work Order ID: 106338
 Parent Item: D4542-5
 Parent Item Name: RETAINER, INNER

Start Date: 8/29/13
 Start Qty: 40.00
 Required Date: 9/13/13
 Required Qty: 40.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
 reva DD verf:EC IPP REV:C 12.05.08 as per dwg revB DD verf:EC IPP
 REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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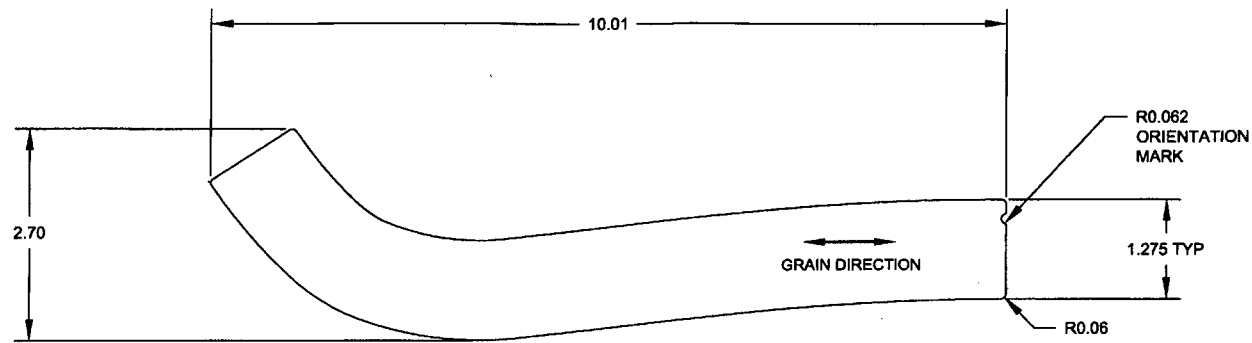
M6061T6S.032		Purchased	No			100	sf	1,096.1660	0.208	87578947			
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code
MAT021	1096.166	
123135	8.5	
123137	10	
123293	10	
123483	256.6	
m125822	67.3	
m126115	74.866	
m126147	305.15	
m126309	363.75	

126309

Jm13-09-10

8 7 6 5 4 3 2 1



D4542-5 RETAINER, INNER
(TOP CORNER)

No 106338

RELEASED
2013-04-22
MB

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REV.D.DXF"

DESIGN	<i>P</i>	DART AEROSPACE LTD	
DRAWN	<i>P</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
DATE	13.02.04	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1